

Date: Monday, 7/9/2007 11:46:44 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	205 SKIDTUBE "I" BEAM
Job Number	33348		
Estimate Number	10346		
P.O. Number	N/A	Part Number	D2596
This Issue	7/9/2007	S.O. No.	D2596 REV C D
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	SD
Previous Run	33058	Material	N/A
Written By		Due Date	7/13/2007
Checked & Approved By	HJ 07.07.09	Qty:	4
Comment	Est: D 90.02.02 Changed QA to QC, Added Step 6 and Cost D	Um:	Each
	M		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - 'I' Beam Web 4"	
			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick: Qty Part Number Description Batch	B31223 RKL 77-16
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
			
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr	77-16
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	77-16
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
		Comment: INSPECT WORK TO CURRENT STEP	77-17
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 46	46 77-17
			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33348

Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

DD 07/07/03

Job Completion



u 07.07.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

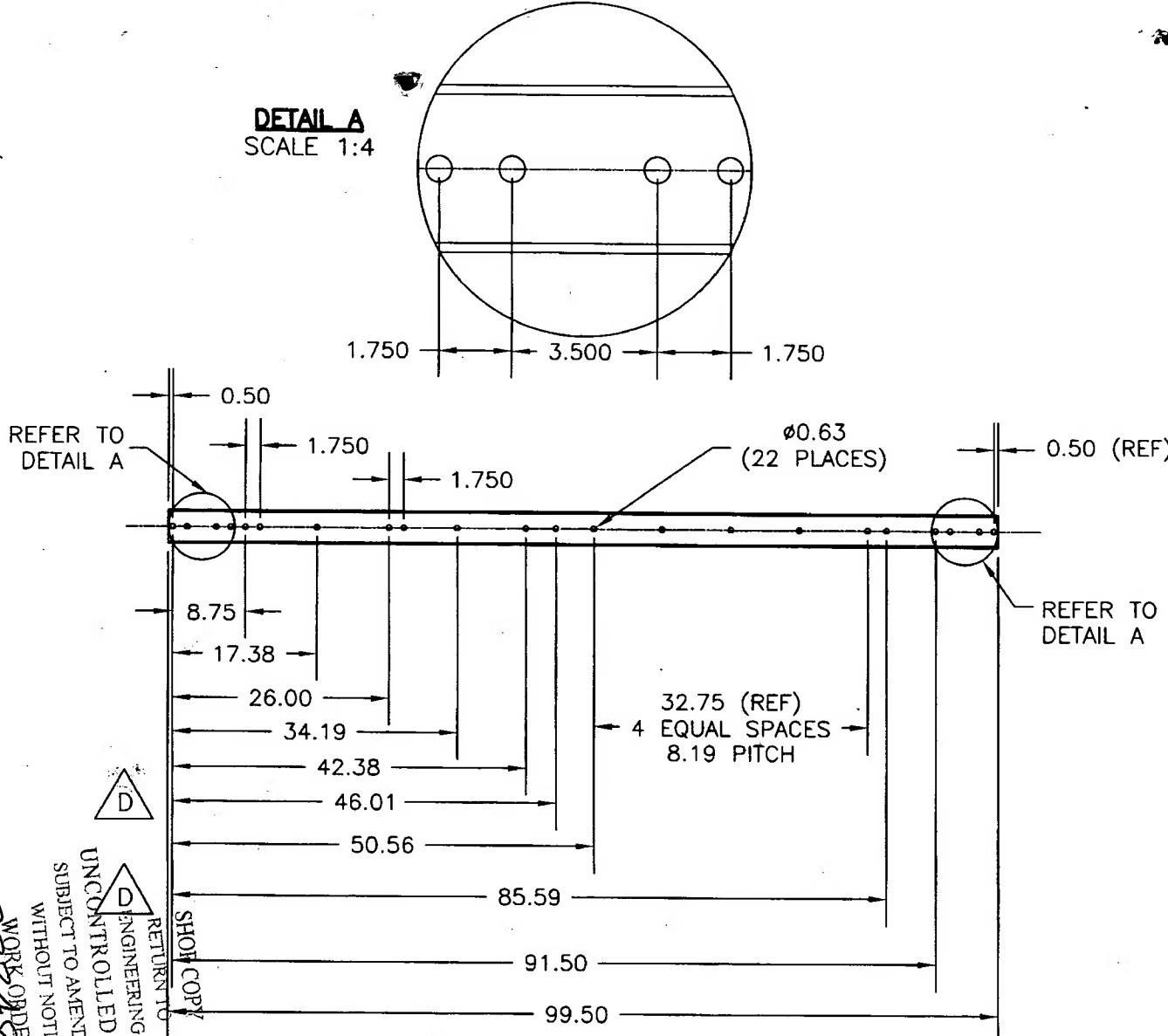
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) DEBURR SHARP EDGES 0.010 TO 0.020

**RELEASED**

07.06.18

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DESIGN <i>RH</i>	DRAWN BY <i>RH</i>
CHECKED <i>MH</i>	APPROVED <i>MH</i>
DATE 07.04.17	DRAWING NO. D2596
	TITLE 205 WEB
	SHEET 1 OF 1
	REV. D
	SCALE 1:20
A B C D	96.09.16 97.07.23 98.09.14 07.04.17
	NEW ISSUE Ø0.63 HOLE WAS Ø0.56 INCORPORATED DEO 9097 INCORPORATED DEO 9183

DART AEROSPACE LTD

Work Order:

Description: Bear paw - 205 Web

Part Number:

Inspection Dwg:

D2596 Rev: D

D2596

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.50	+0.03	.50	✓			
B 1.750	+/- 0.001	1.750	✓			
C 1.750	+/- 0.001	1.750	✓			
D 0.50 (REF)	+/- 0.03	.470	✓			
E 8.75	+/- 0.03	8.75	✓			
F 17.38	+/- "	17.38	✓			
G 26.00	+/- "	26.00	✓			
H 34.19	+/- "	34.19	✓			
I 42.38	+/- "	42.38	✓			
J 46.01	+/- "	46.01	✓			
K 50.56	+/- "	50.56	✓			
L 32.75	+/- "	32.75	✓			
M 8.19	+/- "	8.19	✓			
N 85.59	+/- "	85.59	✓			
O 91.50	+/- "	91.50	✓			
P 99.50	+/- "	99.50	✓			
Q						
R Detail A						
S						
T 1.750	+/- 0.001	1.750	✓			
U 3.500	+/- "	3.500	✓			
V 1.750	+/- "	1.750	✓			

Measured by:

DP

Audited by:

RL

Prototype Approval:

N/A

Date:

7-7-12

Date:

07.07.12

Date:

N/A

Rev:

Date:

Change

Revised by:

Approved:

A

JULY 14, 2012

New Issue

KJ/RF

N/A

OGG di  
OGG di  
OGG di  
OGG di

OGG di